

Tuesday, March 17, 2015 11:53:25 AM

130615

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: D2893-1 Turning Detail

Start Date: 3/17/2015 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 3/17/2015 **Req'd Qty:** 8.00

g

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-03-17 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130615

130615

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Tuesday, March 17, 2015 11:53:25 AM

Item ID: DSK078 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: D2893-1 Turning Detail
Start Date: 3/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 3/17/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 40 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MATOGO								15/04/15
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									04- MLJ 15- 07 15 MF 15-4-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Tuesday, March 17, 2015 11:53:28 AM

Page 1

Work Order ID: 130615

130615

Parent Item: DSK078

DSK078

Parent Item Name: D2893-1 Turning Detail

Start Date: 3/17/2015

Required Date: 3/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	6.0000		8		DAS	
D6104-005									**			37	
Round Billet, 17-4												9-89	15-04-14
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT043			6						
				130026			6						
				130690			8						
										8			

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	130615
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.954	4.954	4.955	4.955	4.955
C	3.064	3.084		3.071	3.071	3.072	3.071	3.071
D	0.718	0.738		.730	.730	.733	.733	.734
E	0.090	0.110		.095	.095	.095	.095	.094
F	2.934	2.954		2.940	2.940	2.941	2.941	2.942
G	2.166	2.186		2.177	2.177	2.176	2.176	2.176
H	3.890	3.910		3.899	3.899	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.925	.925	.925
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.117	.118	.117	.118
L								
M								
N								
O								
P								

Measured by:	DAS 37	Date:	15.04.14
Audited by:	9-89 DAS 40 9-89	Date:	15/04/15
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	130615
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

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E	0.090	0.110		.095	.095	.095		
F	2.934	2.954		2.940	2.940	2.940		
G	2.166	2.186		2.177	2.177	2.177		
H	3.890	3.910		3.900	3.899	3.900		
I	0.914	0.934		.924	.924	.925		
J	0.022	0.042		.032	.032	.032		
K	0.109	0.129		.117	.117	.117		
L								
M								
N								
O								
P								

DAS

Measured by: 37

9-89

DAS

Date: 15.04.15

Audited by: 40

9-89

Date: 15/04/15

Prototype Approval:

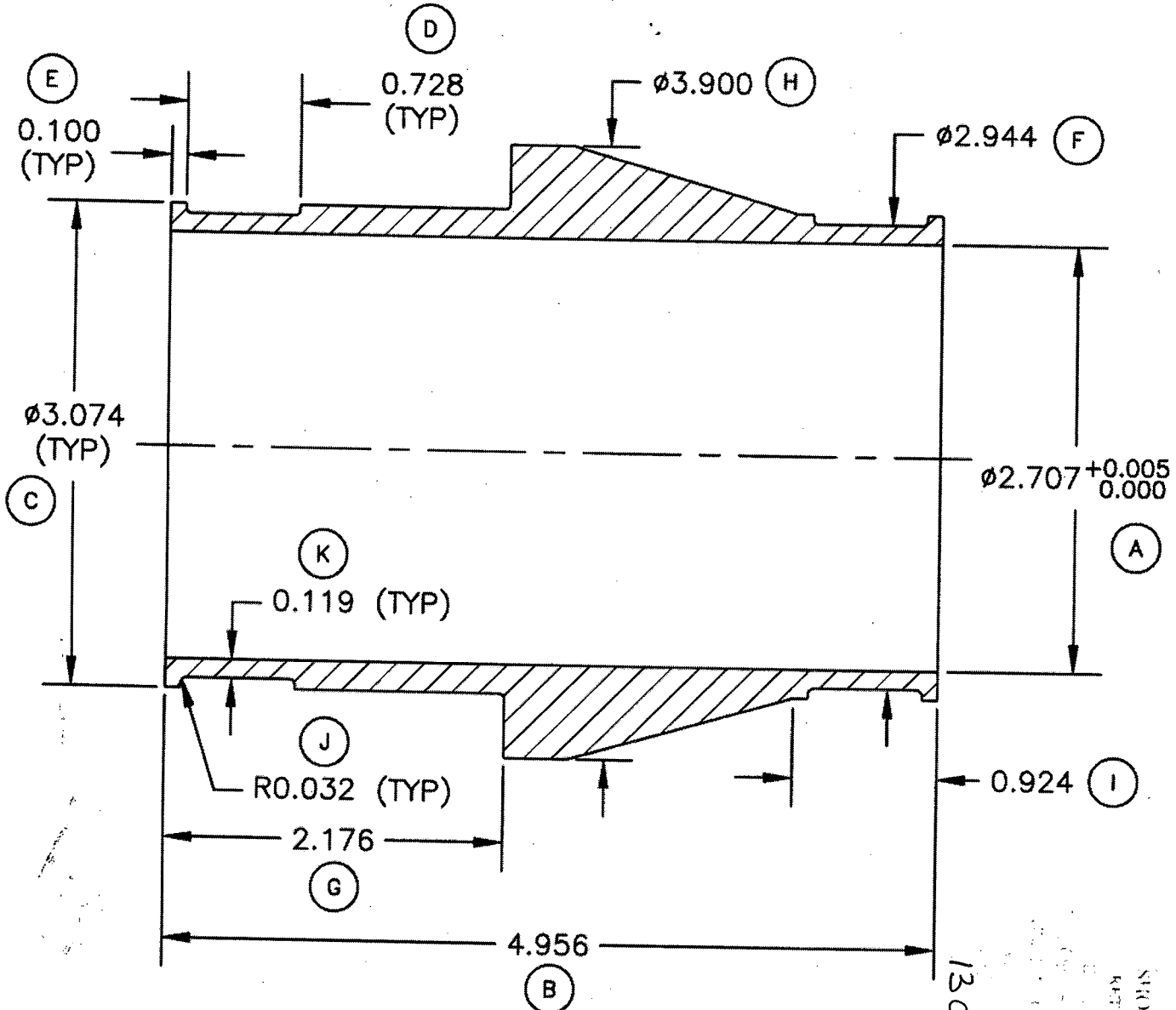
Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

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15-03-17

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